

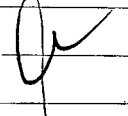
Work Order ID 126823

126823

Page 1

November-26-14 12:50:27 PM

Item ID: D3651-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Flange Weldment
 Start Date: 11/26/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/05/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3651	Rev B								

100 Large Fab 0.00
100
 Large Fab Memo 0.00 6 14-11-27
 Large Fab Weld assembly as per dwg D3651

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00 6 14-11-27
 Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.00 6 14-11-27
 Quality Control

DAS
9
9-89

DAS
9
9-89

Work Order ID 126823***126823***

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November-26-14 12:50:27 PM

Item ID: D3651-043 Accept ***N900040100*** Setup Start ***NS1***
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

14/12/10 *[Signature]*
MF
14-129

Picklist Print

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Page 1

Work Order ID: 126823

126823

Parent Item: D3651-043

D3651-043

Parent Item Name: Flange Weldment

Start Date: 11/26/14

Required Date: 12/05/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CR3523-4-02 *CR3523-4-02* RIVET		Purchased	No			130	Each	674.0000	57	28 342		DAS 28 9-89	DEC 04 2014
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CCK004		574							
				m130415		574							
				GA		100							
				m130415		100				28 342			
D3651-3 *D3651-3* Base		Manufactured	No			130	Each	1.0000	1	16		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1				110351 X1			
				108123		1				111083 X4			DEC 02 2014
D3651-5 *D3651-5* Top Flange		Manufactured	No			100	Each	0.0000	1	16			
				126525 X6									
D3651-7 *D3651-7* Bottom Flange		Manufactured	No			100	Each	0.0000	1	16			
				126526 X6									
										EL 14-11-26			
										EL 14-11-26			

Picklist Print

November-26-14 12:50:26 PM

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Work Order ID: 126823

126823

Parent Item: D3651-043

D3651-043

Parent Item Name: Flange Weldment

Start Date: 11/26/14

Required Date: 12/05/14

Start Qty: 4.00

Required Qty: 4.00

MS20427M3-3

Purchased

No

130

Each

2,357.000

16

64 96

MS20427M3-3

Rivet

**

DAS
28
9-89

DEC 08 2014

Location

Loc Qty

Loc Code

GA

10

121114

10

ST311

2347

m129864

422

m130922

1925

64 96x

MS21060-3K

Purchased

No

130

Each

198.0000

8

32 48

MS21060-3K

Nut Plate

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST302

198

m129864

66

m129913

32

m130953

100

32x
16x

8 7 6 5 4 3 2 1

D

C

B

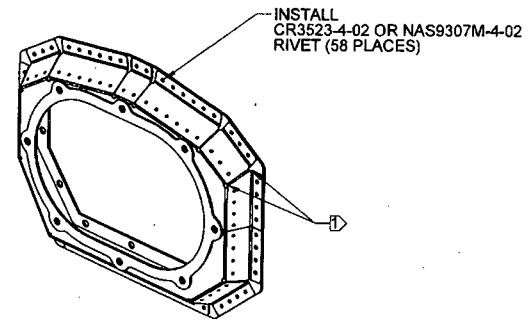
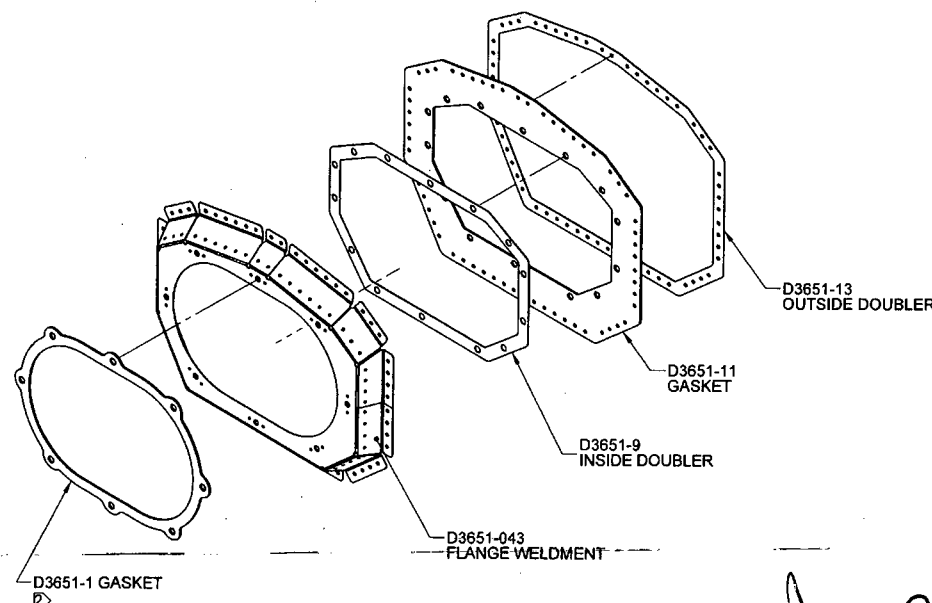
A

D

C

B

A



PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

w/o 126823

D3651-041 AFT BASE ASSEMBLY

RELEASED
08-03-27/10

- D3651-041 NOTES:
- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
 - 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3651	SHEET 1 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AFT BASE ASSEMBLY	1:4
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

TRANSFER DRILL $\varnothing 0.129$ (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)

MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

GTAW
GRIND FLAT TO
CLEAR FASTENERS
(2 PLACES)

D3651-5 TOP FLANGE

D3651-7 BOTTOM FLANGE

D3651-5
TOP FLANGE
(REF)

D3651-7
BOTTOM FLANGE
(REF)

D3651-3
BASE

0.88 (REF)

D3651-043 FLANGE WELDMENT

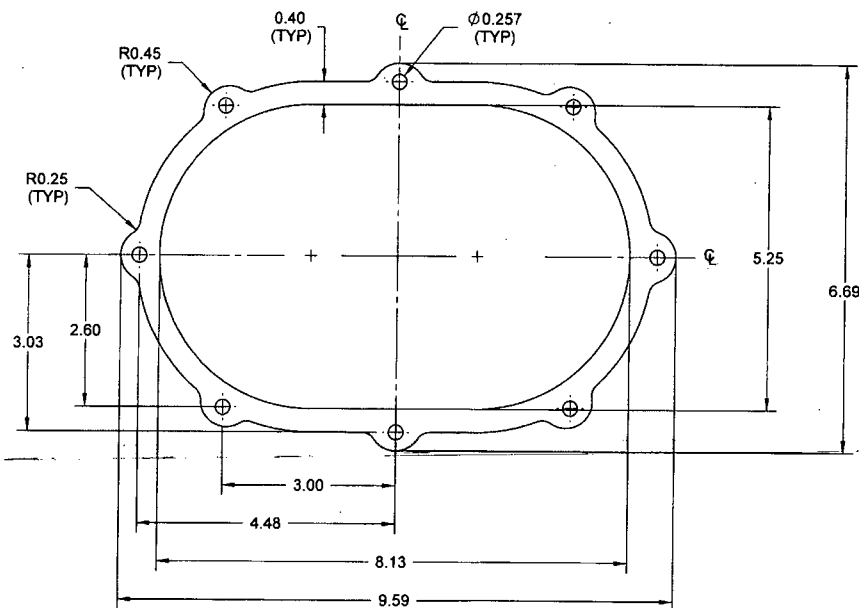
QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NAS9307M-4-02	RIVET

RELEASED
08-03-27/100

D3651-043 NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.76 lbs

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MFG. APPR.	ME	D3651	SHEET 2 OF 9
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DE APPR.	ME	AFT BASE ASSEMBLY	1:3
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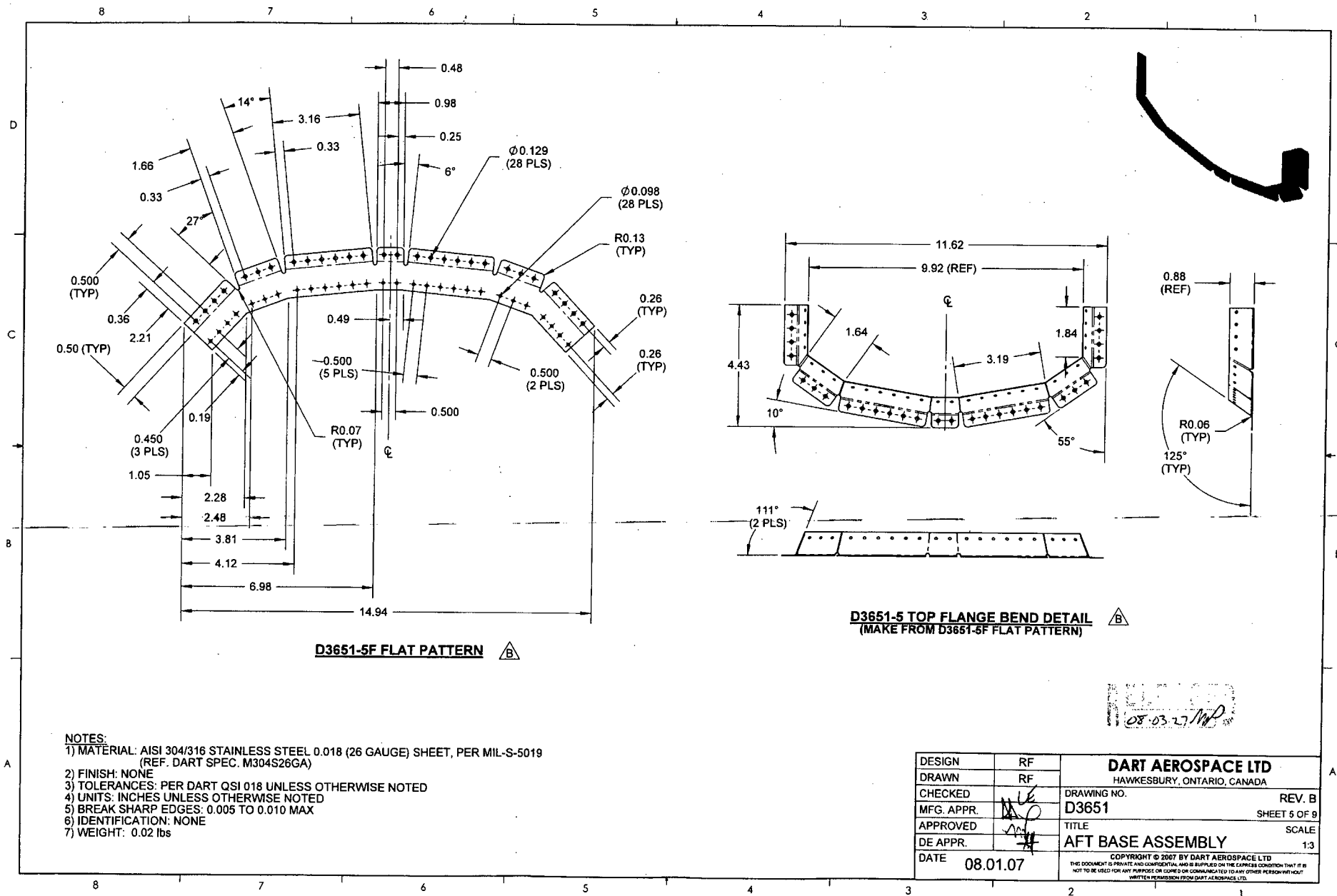
D3651-1 GASKET

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs

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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3651	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 8	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT BASE ASSEMBLY	1:2
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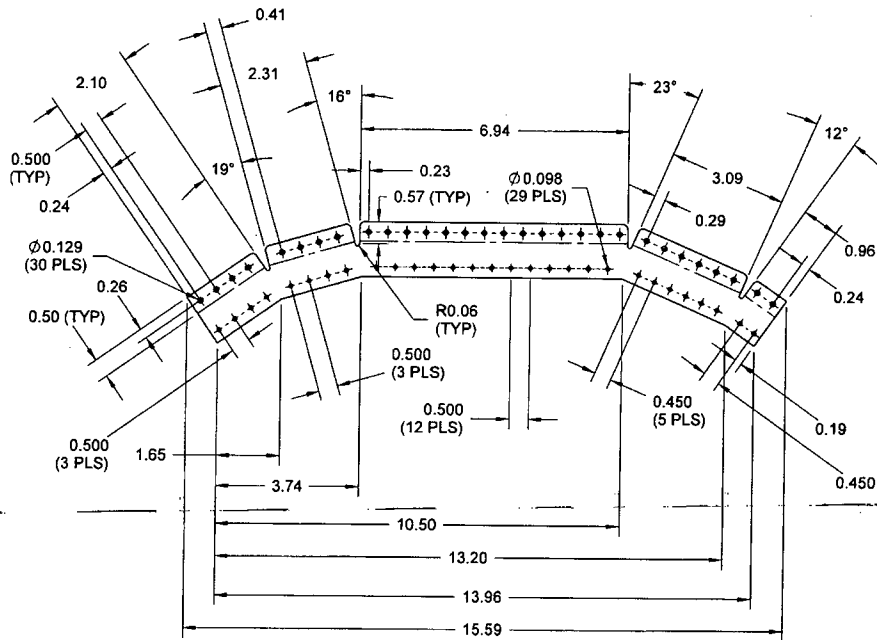
8 7 6 5 4 3 2 1

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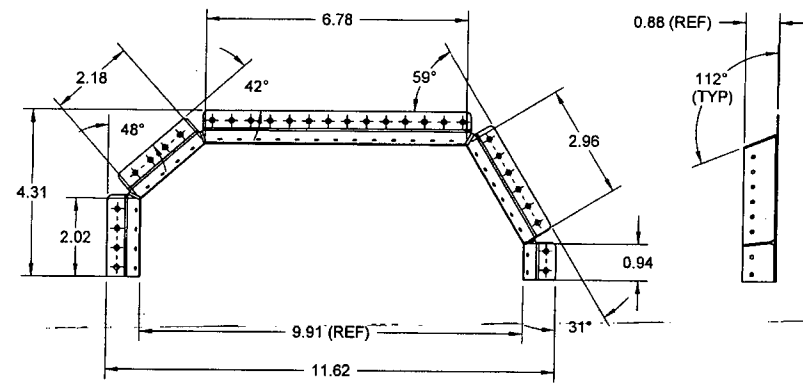
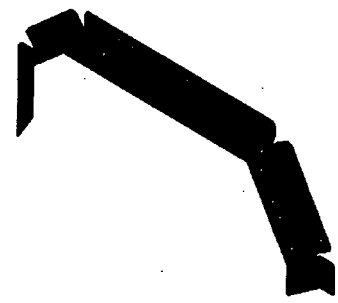


D3651-7F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

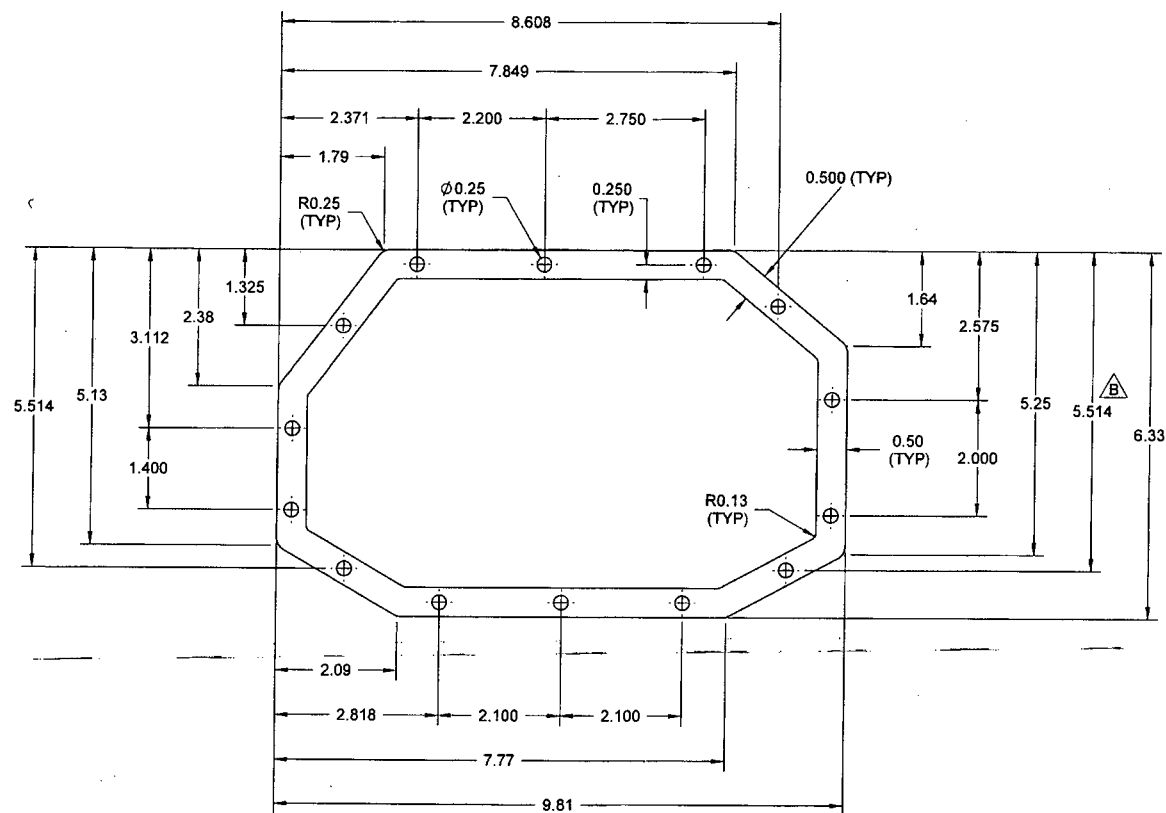
8 7 6 5 4 3 2 1



D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

08-03-27

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3651	SHEET 6 OF 9
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:3
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D3651-9 INSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WLE	DRAWING NO.	REV. B
MFG. APPR.	WLE	D3651	SHEET 7 OF 9
APPROVED	WLE	TITLE	SCALE
DE APPR.	WLE	AFT BASE ASSEMBLY	1.2
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